

Work Order ID 98121

98121

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March-07-13 12:30:26 PM

Item ID: D119-646-211 Accept *N900040100* Setup Start *NS1*
 Revision ID: ~~D119-646-211~~ Stop *NS2*
 Item Name: Skidtube STD w/ Training Wearplates, LH
 Start Date: 3/07/13 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 3/07/13 Req'd Qty: 1.00 *1* Customer:
 Reference: REWORK-ECN13-534

Approvals: Process Plan: W Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN-D119-646	B

100

0.00

100

DC

Document Control

Memo

0.00

Photocopy bluefile & type labels per PPP D119-646-211
 CHG004 PER ECN13-534

forms 13-3-12

DART Dart Aerospace Ltd. 1270 ABERDEEN ST. HAWKESBURY, ON CANADA K6A 1K7		TC APPROVAL #09-88 TEL: 1-613-632-5200	
P/N	D119-646-211	CHG	CHG003
DESC.	Skidtube STD, LH	SIC	SR02024SE
LOT	B91561	SIC	
MODEL	Agusta A119/AW119MKII	SIC	
PATENTS US #5735484 CA #2222184 EUROPEAN No #0828655		MADE IN CANADA 027292	

102

0.00

102

HandFinish

Hand Finishing

Memo

0.00

PULL FROM STOCK:
 1 X D119-646-211 B91561
 REMOVE FWD CAP, PUT ASIDE TO REINSTALL

104

0.00

104

Skidtubes

Skidtubes

Memo

0.00

COUNTERSINK MOST FWD HOLES TO 0.385 X .100 DEG ON BOTH SIDES
 PER DSL 0504
 DETAIL

B98121LH

13-3-11

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
105 *105* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00/ DAS 16 0.00 2-82 13/3/14							
106 *106* HandFinish Hand Finishing	Memo -RE-ALODINE AFFECTED AREAS -TOUCH UP WITH IMRON	0.00 0.00							164 13/3/14
107 *107* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							1 13-3-12 

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 Required Date: 3/07/13 Req'd Qty: 1.00 ***1*** Customer:
 Reference: REWORK-ECN13-534

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
108		0.00							
108									
HandFinish	Memo	0.00							
Hand Finishing	REPLACE FWD CAP USING MS24694-C52 SCREWS SIKAFLEX B <u>M12345</u>								
109	QC5- Inspect part completeness to step on W/O	0.00							
109									
QC	Memo	0.00							
Quality Control									
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging	ENSURE ORIGINAL KIT IS PUT IN BOX								

Handwritten: 108 109 110 13/03/12

Handwritten: DAS 16 9-89 13/3/12

Handwritten: DAS 06 9-89 13/3/20

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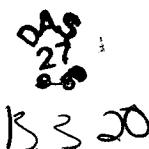

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 Reference: REWORK-ECN13-534

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 				1			
130 *130* Packaging Packaging	Memo RE-PACKAGE PER PPP USING NEW B/N @ CHG 004 NEW LABELS AND DSI PAPERWORK REQ'D Identify and pack for shipping as per PPP D119-646-211 Location: <u>043</u> PPP rev: <u>C</u>	0.00 0.00					DAS 06 2013	13/3/20	
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00				ML5		13-03-21	

h 130321

Picklist Print

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Work Order ID: 98121

Parent Item: D119-646-211

Start Date: 3/07/13

Required Date: 3/07/13

Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC
644 DD verf:JLM IPP Rev:B 12.09.12 as per ECN12-
IPP REV:C 12.11.05 raise to chg003 (ECN 12-675) DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D119-646-211		Manufactured	No				Each	0.0000		1		9/56/1	W 3/03/11
Skidtube STD w/ Training Wearplates, LH													
MS24694-C52		Purchased	No				Each	192.0000		2		13/03/21	
Screw													
				Location			Loc Qty		Loc Code				
				ST301			192						
				124291			92			X2			
				124308			100						

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D119-646 REV. B,
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D119-646 REV. 1 OR EARLIER,
REF. FAA STC SR02024SE

1.0 PURPOSE

The purpose of this DSI is to provide instructions for customers to modify the forward end of the D119-646-XXX skidtubes using the DSI 9594-011 Kit to make the skidtubes compatible with the Agusta ground handling wheels. One kit modifies 2 skidtubes. After CHG 001, portions of this modification may have been incorporated in production and therefore will not need to be incorporated in the field.

2.0 PROCEDURE

Modify the skidtubes as follows:



- 2.1 Rotate the D3407-041 Tow Ring to the vertical position as necessary.
- 2.2 Mark holes in the center ridge as shown in Figure 1. Drill through skidtube with Ø0.500" (12.7 mm drill), and countersunk to Ø0.650 x 100°, two places per side.
- 2.3 Remove and discard the hardware retaining the forward Cap. Countersink the existing holes to Ø0.385 x 100°.
- 2.4 Deburr holes. Touch up affected areas with chemical film material (Alodine 1200 or 1201) per MIL-C-5541.
- 2.5 Bond D2579 spacers into the Ø0.500 holes center in the skidtube using Magnobond 6398. Grind flush prior painting as shown in Figure 1.
- 2.6 Apply one coat of MIL-P-85582 or MIL-P-2337 primer and 2-3 coats of MIL-C-83285 polyurethane coat to match original finish.
- 2.7 Fasten the forward Cap using MS24694-C52 Screws. Seal threads with Proseal 890. Ensure that screw heads sit below skidtube surface
- 2.8 Repeat steps 2.1 to 2.7 for opposite skidtube.

3.0 PART LIST

Qty -011	PART NUMBER	DESCRIPTION
X	DSI 9594-011	FWD GROUND HANDLING SPACER KIT
4	D2579	CROSS BOLT SPACER
4	MS24694-C52	SCREW

4.0 WEIGHT AND BALANCE

This modification has negligible effect on weight and balance.

B	ADD INSTRUCTION TO REMOVE EXISTING CAP MOUNTING HARDWARE AND REPLACE WITH COUNTERSUNK SCREWS	DB	13.02.20
A	NEW ISSUE	RF	12.02.03
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA DRAWING NO. DSI 9594 TITLE FWD GROUND HANDLING SPACER KIT SCALE NTS SHEET 1 OF 2 REV. B COPYRIGHT © 2012 BY DART AEROSPACE USA, INC. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	
DRAWN	DB		
CHECKED	MB		
MFG. APPR.	N/A		
APPROVED			
DE APPR.			
DATE	13.02.20		

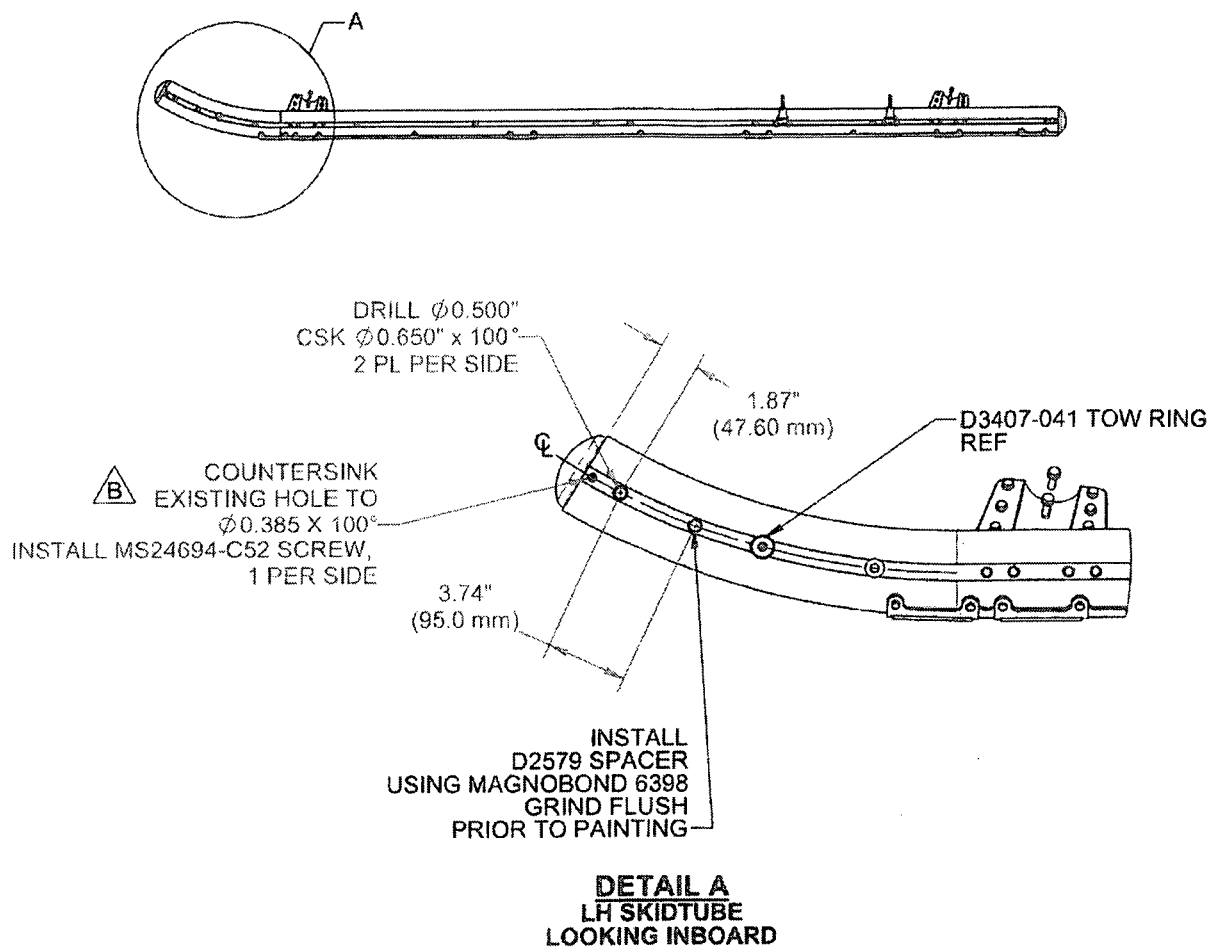


FIGURE 1. MODIFIED D119-646-XXX SKIDTUBE

DESIGN	RF	DART AEROSPACE USA, INC	
DRAWN	DB	KENT, WA	
CHECKED	MB	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9594	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FWD GROUND HANDLING SPACER KIT	NTS
DATE	13.02.20	COPYRIGHT © 2012 BY DART AEROSPACE USA, INC <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC</small>	

Linda Lacelle

From: Mike Petsche
Sent: March-06-13 10:27 AM
To: Linda Lacelle; David Shepherd
Cc: Eric Downing
Subject: RE: 119 skids

Yeah that's pretty much the gist of it. The DSI had been for A-W to do the mod for the aircraft that is here at the show. But for any stock/WIP you have, do exactly what you just said.

Dave (Bain) has updated the dwgs. An ECN should not be terribly far off. (I'm checking with him now to see where it is)

From: Linda Lacelle
Sent: Wednesday, March 06, 2013 7:36 AM
To: David Shepherd
Cc: Mike Petsche; Eric Downing
Subject: RE: 119 skids

Thx David. I'm a bit confused though, this DSI is for the customer when in the field correct? All we have to do is countersink the holes for the cap, re-alodine, touch up, replace cap with screw, correct?
LL

From: David Shepherd
Sent: March-05-13 2:32 AM
To: Mike Petsche; Linda Lacelle
Subject: RE: 119 skids

Linda,

I am good with modifying the front end of the 119 skidtubes to the attached DSI.

Regards,
David

From: Mike Petsche
Sent: March-04-13 10:17 AM
To: Linda Lacelle; David Shepherd
Subject: FW: 119 skids

fyi

From: David Bain
Sent: Monday, March 04, 2013 12:06 PM
To: Mike Petsche
Subject: RE: 119 skids

Mike,

ECN B.534

-211 x 2 skt - 98721 > 91
- 98722 x 1

wip > 93010 94837
93011
93012
93013
93014

- 212 x 3 skt

wip > 91627
93016 93019
93017
93018

new order
987379
987429
98725
98726 > 91